

6104-05

OK * Reprint 2x

Work Order ID 144758

144758

Page 1

Wednesday, July 06, 2016 8:11:21 AM

Item ID: D5124-1TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 05/04/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 05/18/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5124

B

100

0.00

100

Doosan

Memo

17.70

Doosan Lathe

Turn blank as per Folio FB340

DAS

45

9-89

2016-7-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.10

Quality Control

DAS

45

9-89

2016-7-5

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.20

Quality Control

DAS

49

9-89

16/07/11

DQA:

Date: 16.08.09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/07/20

Work Order update only ☐

Work Order: 144758		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. 05124-1TRN		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. 16-5924		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16-07-15		Step #: 100		QTY Effective: 1			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				PD 16-07-13	
dimension 0.136 0.136 top miss a lip at one end.				Scrap and destroy replace B 144957				Completed By DAS 45706-7-10 9-89 Lead hand / Supervisor Approval Verification DAS 14 9-89 16/07/10	
								QC / QA Coordinator Approval DAS 38 9-89 JUL 13 2016	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☒	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☒	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 144758

Wednesday, July 06, 2016 8:11:21 AM

144758

Page 2

Item ID: D5124-1TRN Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 05/04/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 05/18/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				10	0		49 9-89
130	Memo	0.00							16/07/11
Packaging	Identify and Stock in Kanban								
Packaging	Location: <u>Mat 060</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140	Memo	1.00							
QC									
Quality Control									

DAS
21
9-89 JUL 14 2016

DAS
21
9-89 JUL 13 2016

Picklist Print

Wednesday, July 06, 2016 8:11:20 AM

Page 1

Work Order ID: 144758

144758

Parent Item: D5124-1TRN

D5124-1TRN

Parent Item Name: Support

Start Date: 05/04/2016

Required Date: 05/18/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A RQ verified by JLM 14/08/08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	31.0000		10			
D6104-005									**				
Round Billet, 17-4													

Location

Loc Qty

Loc Code

MAT043

31

144227

11

144957

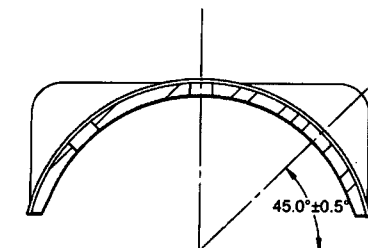
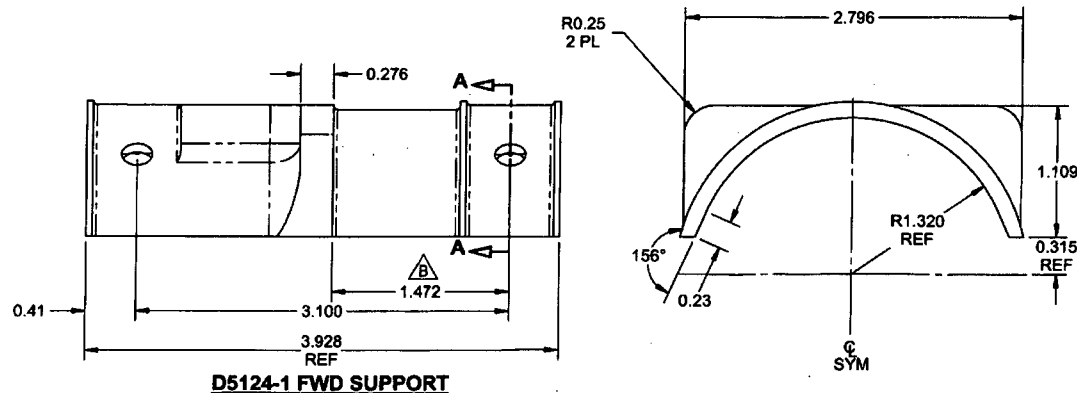
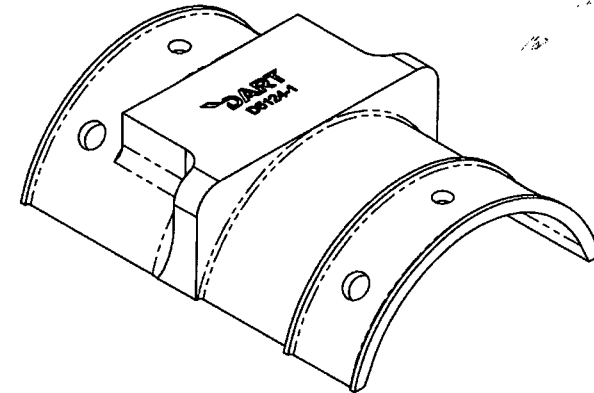
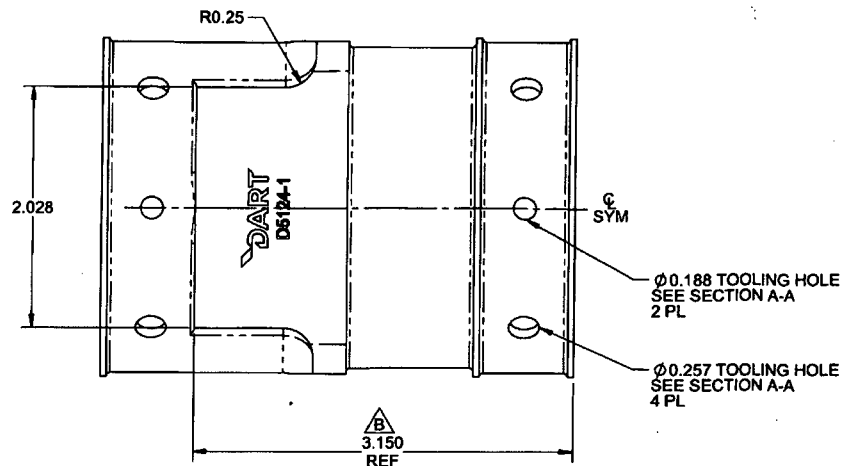
20

DAS

45

9-89

2016-7-9



SECTION A-A RELEASED

2014 NOV 18

NOTES:

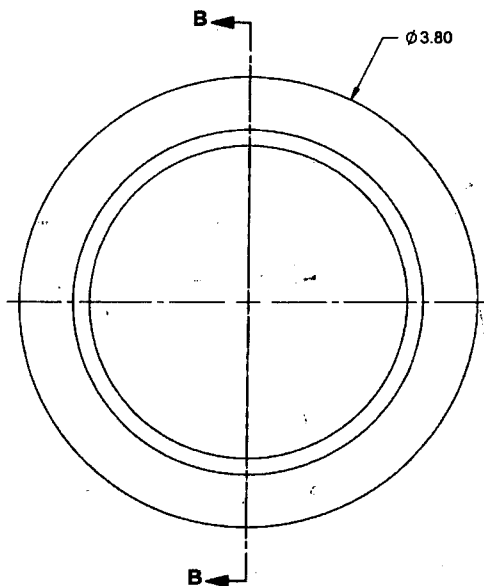
- 1) MATERIAL: MAKE FROM D5124-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5124-1" IN AREA SHOWN USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3, IDENTIFY WITH DART B/N PER DART QSI 044 6.1

7) WEIGHT: 0.53 lbs

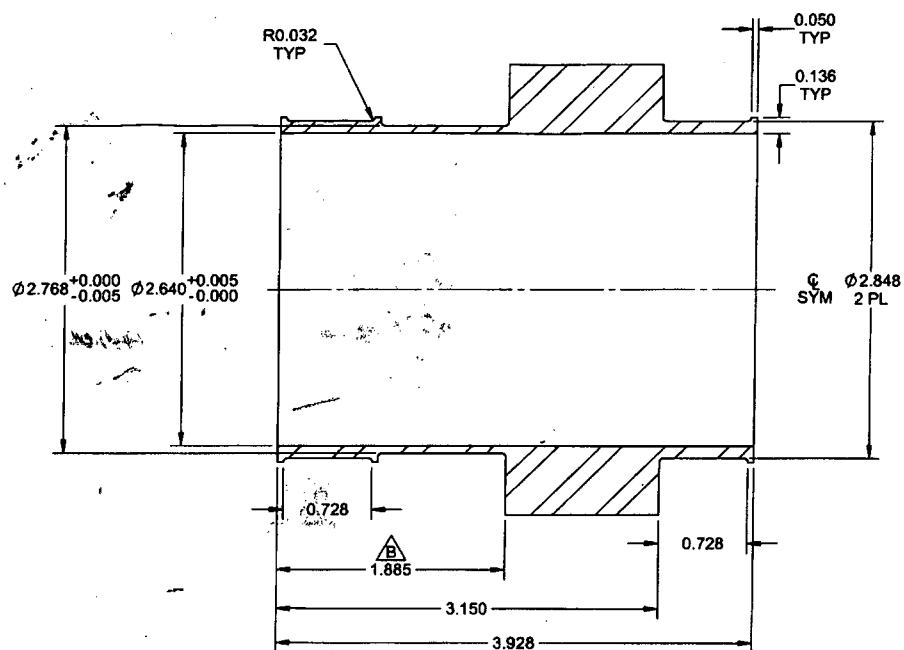
8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5124-1-REVB.SLDPRT"

APPROVED

B	DIMENSIONAL CHANGES RESULTING FROM FIRST TEST FIT. SEE REV A FOR DETAILS	AP	14.10.28
A	NEW ISSUE	AP	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	RQ	D5124	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	FWD SUPPORT	NTS
DATE	14.10.28	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5124-1TRN FWD SUPPORT



SECTION B-B

RELEASED

2014 NOV 18

NOTES:

- 1) MATERIAL: 17-4PH/S17400/TYP 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.74 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	RQ	D5124	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	FWD SUPPORT	NTS
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144758

